

Date: Monday, 1/7/2008 3:38:16 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|---------------|
| Customer | CU-DAR001 Dart Helicopters Services | Drawing Name | RADIUS BLOCK |
| Job Number | 36624 | | |
| Estimate Number | 10822 | | |
| P.O. Number | : | Part Number | : D2274 |
| This Issue | : 1/7/2008 | Drawing Number | : D2274 REV F |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / | Drawing Revision | : F |
| Previous Run | : 35205 | Material | : |
| Written By | : | Due Date | : 1/21/2008 |
| Checked & Approved By | : <i>JL 08.01.8</i> | Qty: | 500 Um: Each |
| Comment | : Est. H00.05.18 Added inspection level 8 EC | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|--|---------------------|
| 1.0 | M6061T6B0750X00125 | 6061-T6 Bar .75" x .125" | |
| | | Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s) 6061-T6 Bar .75" x .125" | <i>JNL 08/02/16</i> |
| | | Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch <i>H104705</i> | |
| 2.0 | SHEAR | SHEAR | |
| | | Comment: SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces | <i>JNL 08/02/16</i> |
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 | |
| | | Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274 | <i>JNL 08/02/17</i> |
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | <i>JNL 08/02/17</i> |
| 5.0 | QC8 | SECOND CHECK | |
| | | Comment: SECOND CHECK | <i>JNL 08/02/18</i> |
| 6.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling | <i>JNL 08/02/18</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/22
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 3:38:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 36624

Part Number: D2274

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



557

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BK 08-02-19

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



557X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/02/19

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 24

AR 08/02/19 X 557

557

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Do 08/02/19

Job Completion



= 2008/2/19

557

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | |
|---------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 36624 |
| Description: Radius Block | Part Number: | D2274 |
| Inspection Dwg: D2274 | Rev: F | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

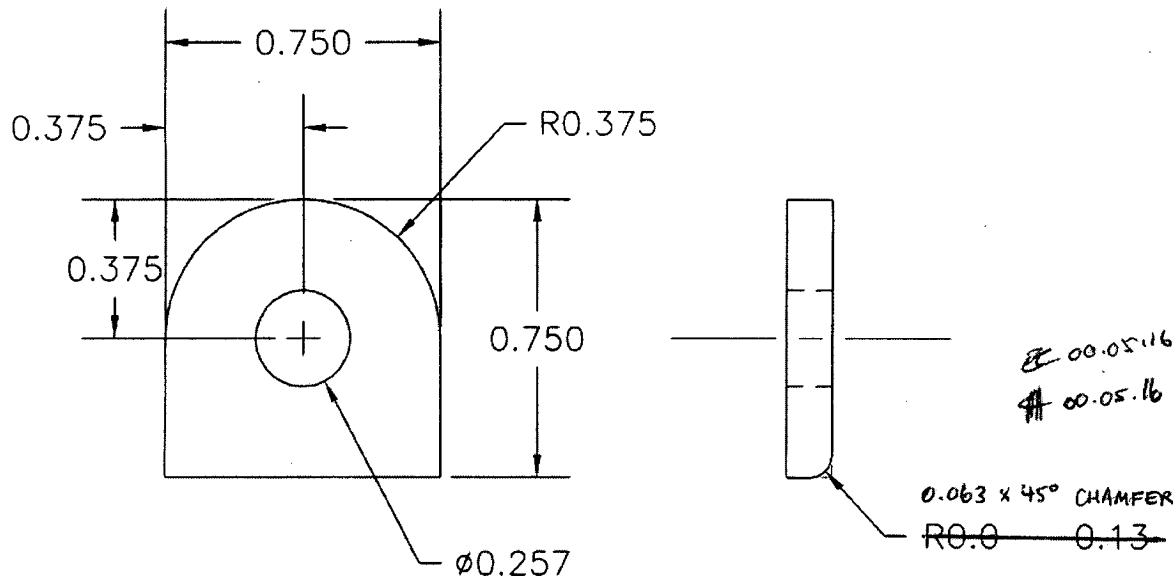
| | | | | | |
|--------------|---|-------------|---|---------------------|--|
| Measured by: |  | Audited by: |  | Prototype Approval: | |
| Date: | 08/02/12 | Date: | 08-02-12 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|---------------|-------------------|-----------------|
| A | 03.10.07 | New Issue | KJ/RF | |



| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN KE | DRAWN BY KE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>MJ</i> | APPROVED <i>GS</i> | DRAWING NO. D2274 | REV. F SHEET 1 OF 1 |
| DATE 98.08.11 | | TITLE RADIUS BLOCK | SCALE 2:1 |
| A | 94.09.29 | NEW ISSUE | |
| C | 95.07.12 | RADIUS ENDS | |
| D | 97.03.24 | ADD MATERIAL SPECIFICATION | |
| E | 97.12.12 | ADD FINISH & TOLERANCE QSI | |
| F | 98.08.11 | RO.0 - 0.13 WAS R0.063 - 0.125 | |

RELEASED
98/08/18 KE



SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK WORK ORDER
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 NO. *36624*
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED